

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022499**Date Inspected:** 14-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman Acme Corporation**Location:** Buffalo, NY**CWI Name:** Gregory Ross**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic Joint A Mock-up**Summary of Items Observed:**

On this date, Quality Assurance Inspector Fred Edmondson was present at the Watson Bowman Acme Corporation (WABO) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A Mock-up lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QA) Inspector met with Watson Bowman Acme Corporation Quality Control (QC) Manager Mr. Gregory Ross, Quality Control (QC) Supervisor John Miller and (KTA-Tator, American Welding Society Certified Welding inspector (AWS CWI), and Mr. John Gotwald.inspector on the day shift. Welding has not started on the night shift.

This QA inspector observed certified welder Jayson Gray using the FCAW process to weld Complete Joint Penetration (CJP) welds on the SEI112667CA2 Channel Assemblies for the mock-up. The approved FCAW Welding Procedure Specification (WPS) was Watson Bowman - WPS FCAW 13. All welding was being performed in the 1G flat position.

This QA inspector observed that the two deck plates (Part No. SEI112667AC) for the mock-up were in the same location they were in during my last visit. The welding and re-shaping of the traction patterns had not started.

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Summary of Conversations:

QC Manager Ross informed this QA inspector and QC inspector Gotwald that the Watson Bowman stud welding welding procedure specification (WPS) has been submitted for review and approval. QC Manager Ross commented that stud welding should begin this coming week.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Edmondson,Fred	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
